



PERFECT COMPONENTS.  
PERFECT SYSTEMS.

A MEMBER OF **HTI** GROUP

# PVC Pipe Heads RK

## Application

The RK PVC pipe heads by High Tech Extrusion complement continuing advances in materials, formulations and extruders.

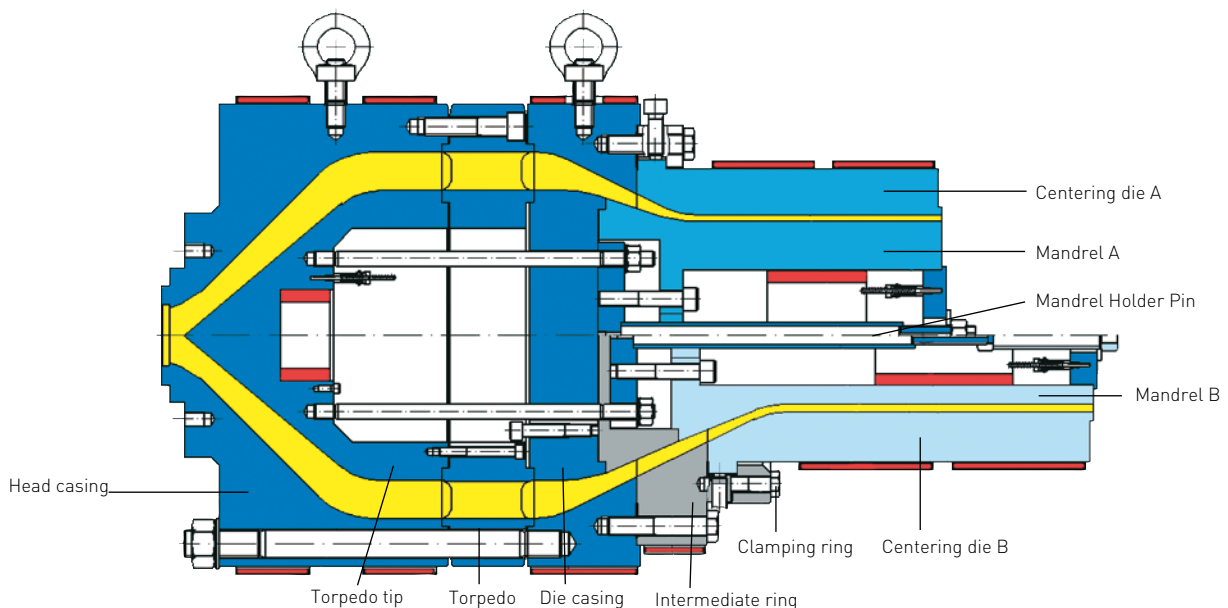
With RK pipe heads, PVC pipes from 16 - 710 mm OD in all pressure classes can be produced. Normal stabilizers in PVC, e.g. Pb, Ca, Zn, Sn, as well as OBS stabilized formulations, C-PVC and foamed PVC (F-Version) can be processed.

## Standard

- high production capacity
- made of chromium plated steel
- optimized flow geometry of pipe heads and die sets
- large head volume allows best relaxation of material
- very small wallthickness tolerance of the pipe
- more than 2000 RK PVC pipe heads are used worldwide

## Options

- stainless steel version X35CrMo17 for pipe heads and die sets
- multi-layer hard-chromium version for C-PVC
- F-version for 3-layer foam core pipes in combination with TW 4-10 Feedback system
- mounting support trolley
- thermal centering die
- hydraulic torque wrench



# Pipe head data

	RKT 1	RKS 1	RK 1.5	RK 2	RK 3	RK 4	RK 5	RK 5.5	RK 6	RK 6.5
Torpedo cross section (cm <sup>2</sup> )	2 x 104	104	114.7	203.4	403.0	675.5	1097.0	1451.7	1704.8	2335.7
Head volume (dm <sup>3</sup> )	10	10	3.56	7.13	19.44	39.20	71.28	97.20	162.00	243.00
min. compression	8:1	8:1	18:1	15:1	12:1	10:1	8:1	6:1	5:1	5:1
Material (*chromium plated)	42CrMo4	42CrMo4	42CrMo4	42CrMo4	42CrMo4	42CrMo4	42CrMo4	42CrMo4	42CrMo4	42CrMo4
Weight of head (empty) (kg)	295	130	160	250	680	1315	2450	3000	3600	4765
Heating zones (head) 1-phase [* heating zones in F-Version]	8	4	3 / 4*	3 / 4*	(6)	-	-	-	-	-
Heating zones (head) 3-phase [* heating zones in F-Version]	-	-	-	-	4 / 5*	4 / 5*	8 / 10*	8 / 10*	8 / 10*	10 / 12*
Heating zones (die set)	4	2	2	2	2	3 - 5	5 - 10	8 - 12	10 - 14	12 - 16
Torpedo tip heating	No	No	Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard
max. output (kg/h)	400	200	210	350	800	1000	→1000	→1000	→1200	→1300

\* requires intermediate ring

Pipe Dimension							Pipe head									
(mm)	Wall thickness / DIN 8062						R K S 1	R K 1.5	R K 2	R K 3	R K 4	R K 5	R K 5.5	R K 6	R K 6.5	
	1.6 bar	4.0 bar	6.0 bar	10 bar	16 bar	>16 bar										
	1	2	3	4	5	6										
12.0	-	-	-	-	1.0	1.4										
16.0	-	-	-	-	1.2	1.8										
20.0	-	-	-	-	1.5	2.3										
25.0	-	-	-	1.5	1.9	2.8										
32.0	-	-	-	1.8	2.4	3.6										
40.0	-	-	1.8	1.9	3.0	4.5										
50.0	-	-	1.8	2.4	3.7	5.6										
63.0	-	-	1.9	3.0	4.7	7.0										
75.0	-	1.8	2.2	3.6	5.6	8.4										
90.0	-	1.8	2.7	4.3	6.7	10.0										
110.0	1.8	2.2	3.2	5.3	8.2	12.3										
125.0	1.8	2.5	3.7	6.0	9.3	13.9										
140.0	1.8	2.8	4.1	6.7	10.4	15.6										
160.0	1.8	3.2	4.7	7.7	11.9	17.8										
180.0	1.8	3.6	5.3	8.6	13.4	20.0										
200.0	1.8	4.0	5.9	9.6	14.9	22.3										
225.0	1.8	4.5	6.6	10.8	16.7	25.0										
250.0	2.0	4.9	7.3	11.9	18.6	27.8										
280.0	2.3	5.5	8.2	13.4	20.8	-										
315.0	2.5	6.2	9.2	15.0	23.4	-										
355.0	2.9	7.0	10.4	16.9	26.3	-										
400.0	3.2	7.9	11.7	19.1	29.7	-										
450.0	3.6	8.9	13.2	21.5	-	-										
500.0	4.0	9.8	14.6	23.9	-	-										
560.0	4.5	11.0	16.4	26.7	-	-										
630.0	5.0	12.4	18.4	30.0	-	-										
710.0	5.7	14.0	20.7	-	-	-										

\*) requires intermediate rings

o) requires additional mandrel holder pin